

DFC 9-89
2015-12-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 140079

140079

Page 2

Thursday, December 17, 2015 3:42:07 PM

Item ID: 647.7712 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Tube
 Start Date: 12/17/2015 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 12/17/2015 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						31	Ø		DAS 40 9-89
QC	Memo	0.00							15/12/24
Quality Control									
130	Identify as per dwg & Stock Location: <u>CCk114</u>	0.00							
130						31			DAS 6 9-89
Packaging	Memo	0.00							JAN 04 2016
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							MCS JAN 05 2016
Quality Control									

MCS JAN 04 2016

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		OTHER : ☐			

Picklist Print

Thursday, December 17, 2015 3:42:07 PM

Page 1

Work Order ID: 140079

140079

Parent Item: 647.7712

647 7712

Parent Item Name: Strut Tube

Start Date: 12/17/2015

Required Date: 12/17/2015

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 12-11-06 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NR0.375		Purchased			No		f	20.2122		1.578947			

M4130NR0 375

4130 steel RD bar .375"

Location

MAT032

m133597

Loc Qty

20.2122

20.2122

Loc Code

1.7 ft

DAS
45
989

2015-12-23

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		OTHER : ☐							



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05110

SHEET 1 OF 1

DWG NO. 647.7700

REV: A

PREPARED
BY

A. QUAN

DATE: 08/21/15

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: STRUT ASSY

APPROVED BY:

ENGR

MFG

QC

EFF.

CURRENT ORDER

TRANSACTION CODES (TC):

A-ADD
R-REVISE

C-CREATE
D-DELETE

REASON: REVISED FINISH CALLOUT AS PER ECR 15-209

SHEET 1, NOTES IS:

ACTION: UPDATE MO & WO

NOTES:

- 1 MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
- 2 MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
- 3 MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
- 4 FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
- 7 WELD IAW MIL-STD-2219, TIG WELD WITH FILLER ROD
- 8 FINISH: CAD PLATE IAW QQ-P-416F CLASS I TYPE II
- 9 MASK THREAD PRIOR TO FINISH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1400391 M03

157218

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED: ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM					
CHANGE CATEGORY				DER REVIEW REQUIRED	
☐ MAJOR ☐ MINOR				☐ YES ☐ NO	

1. MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
2. MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
3. MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
4. FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
7. WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD
8. FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
9. MASK THREAD PRIOR TO FINISH

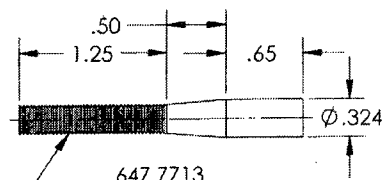
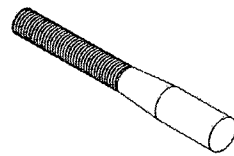
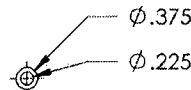
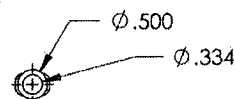
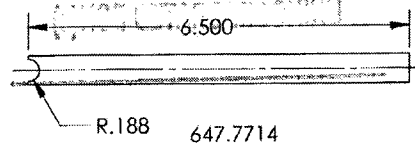
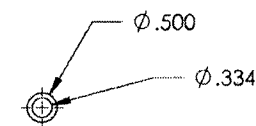
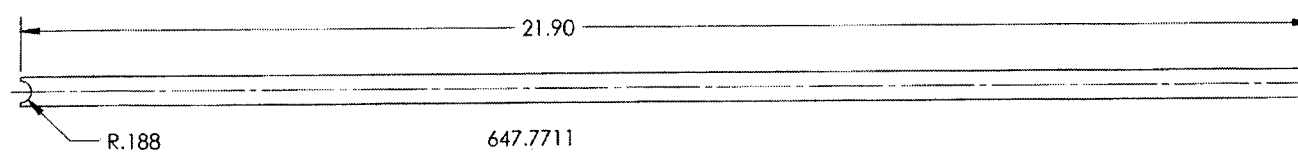
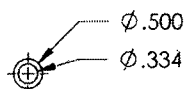
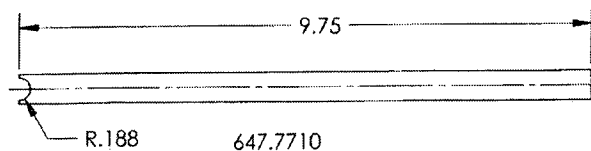
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVAL
	LAST PROTOTYPE REVISION - FPC		N/A
1/1C	24K15 RELEASE	12/20/20	P. DEAYO
A	INCORPORATED ECN DATA	11/13/18	P. DEAYO

UNINCORPORATED ECN(S)

05110

1		5	647.7714	STRUT TUBE	△	
1	1	4	647.7713	STRUT THREAD	△	△
1	1	3	647.7712	STRUT TUBE	△	
	1	2	647.7711	STRUT TUBE	△	
	1	1	647.7710	STRUT TUBE	△	
△	△		647.7703	STRUT ASSY		△ △
△	△		647.7702	STRUT ASSY		△ △
△	△		647.7701	STRUT ASSY		△ △
7703	7702	7701	FIND #	PART #	DESCRIPTION	MAT'L SPEC.
QTY				PART LIST		
NEXT ASSY (\$)				APICAL INDUSTRIES		
647.7300				2608 TEMPLE HEIGHTS DR.		
646.4000				OCEANSIDE, CA. 92036-3512 (760)/724-5303		
SPECIAL DATE: 11/28/89 DRAWN BY: J. JACKSON CHECKED BY: J. JACKSON DESIGNED BY: J. JACKSON CONTRACT NO.:				STRUT ASSY SRE CAGE CODE: 647.7700 R. 07/14/86 CAGE NAME:		
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMAL = ±.01 2 PLACE DECIMAL = ±.005 3 PLACE DECIMAL = ±.001 4 PLACE DECIMAL = ±.0005				DWS NO.: 1 SHEET OF 2		

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1/4 - 28 THREAD

DATE: 11/08/09 DRAWN BY: J. ANDERSON CHECKED BY: J. ANDERSON DRAWING APPROVAL: P. BRAVO CONFIDENTIAL		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SHEET: B CAGE CODE: 07M26 SCALE: NONE	REV. A PART NO: 647.7700 SHEET 2 OF 2
STRUT ASSY			